Work Order ID 105511

August-08-13 8:01:07 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Proeess Plan:** MLS **Date:** 13-08-08 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100		0.00				10			
100	DOCUMENT CONTROL								
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001					DAS 06 13/8/08			
110		0.00				10	0		
110	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 125127 133928								
	3-Grind End Plate flush								

13-08-08

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	**Memo**	0.00				(10)	B08-B		DAS 09
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	**Memo**	0.00				(10)	B-08-13		DC 09
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	**Memo**	0.00				10	8/13 8-15		
Hand Finishing									

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				10	0		DAS 19 13.08.15
150 QC Quality Control	Memo	0.00							
180		0.00				10	0		DAS 19 13.08.15
180 Large Fab Large Fab	Large Fab								
	Memo	0.00							

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod D3272 133938

6-Grind End Plate flush

7-Install last rivet as per Dwg.

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Heli-Access-Step LH **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC10- Inspect visual per QSI004- ground welds	0.00							
190									
QC	Memo	0.00				(10)	B0819		DAS 09 8-8
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00				(10)	B0816		DAS 09 8-8
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00							
210									
HandFinish	Memo	0.00				10	13-819		
Hand Finishing									

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220 Powdercoat									
Powder Coating	**Memo** START TIME: 12:05 OVEN TEMPERATURE: 320°F FINISH TIME: 12:30	0.00							
M126125						10 X ϕ		M/L 13/08/22	
						LH			
230	Wing Walk as per dwg QSI005 4.4 Batch M126263.								
230 HandFinish									
Hand Finishing	**Memo**	0.00				10	ϕ		13-8-26.
240	QC3- Inspect Part Finish	0.00							
240 QC									(DAS 05) 13.08.27
Quality Control	**Memo**	0.00				10			

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00				10			13/8/27 (10)
250									
Packaging	**Memo**	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							13/8/27
260									
QC	**Memo**	0.00							
Quality Control									
270		0.00							
270	Packaging								
Packaging	**Memo**	0.00				10			13/8/27
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location: HALL								

Work Order ID 105511

August-08-13 8:01:08 AM

105511

Item ID: D350-591-311 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Heli-Access-Step LH **Stop** *NS2*

Start Date: 8/08/13 **Start Qty:** 10.00 *10*

Required Date: 8/15/13 **Req'd Qty:** 10.00 *10*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLS 13-08-28

MLS 13-08-28

Picklist Print

August-08-13 8:01:12 AM

10

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter. ref NCR08-082 LL verifed by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 *D3272-1* STEP		Manufactured	No			110	Each	20.0000	1 **	10		13.08.08	
				Location		Loc Qty		Loc Code					
				WA003	B101151	20				10			
					101150	10							
					101526	10							
D3067-1 *D3067-1* END PLATE		Manufactured	No			110	Each	552.0000	1 **	10		13.08.08	
				Location		Loc Qty		Loc Code					
				WA		5							
					95515	5							
				WA003		547							
					101785	244							
					102662	112				10			
					102686	165							
					67582	2							
					68214	1							
					78608	4							
					79607	1							
					83855	1							
					90178	1							
					90486	3							
					95930	4							
					96228	9							

Picklist Print

August-08-13 8:01:12 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

D3219-1	Manufactured	No		110	Each	250.0000	2	20

D3219-1

PLATE

**

13.08.08

Location	Loc Qty	Loc Code	
WA	82		~~20~~
101460	82		12
WA003	168		
101847	48		8
101870	60		
73410	12		
77674	6		
89967	2		
96128	40		

D3066-1	Manufactured	No		180	Each	178.0000	2	20

D3066-1

Spacer

**

13.08.15

Location	Loc Qty	Loc Code	
WA003	178		
101818	174		20
95963	4		

MS20600-AD4W4	Purchased	No		180	Each	6.236.000	16	160

MS20600-AD4W4

Rivets

**

13.08.15

Location	Loc Qty	Loc Code	
ST	5000		
125577	5000		160
ST311	374		
123900	350		
125406	24		
ST506	862		
125654	862		

Picklist Print

August-08-13 8:01:12 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

D3065-041	Manufactured	No		180	Each	59.0000	1	10

D3065-041

Step Leg Assembly

**

13.08.15

Location	Loc Qty	Loc Code
WA	40	
102398	40	
WA003	19	
101572	13	
103737	5	
79336	1	

D3067-1	Manufactured	No		180	Each	552.0000	1	10

D3067-1

END PLATE

**

13.08.15

Location	Loc Qty	Loc Code
WA	5	
95515	5	
WA003	547	
101785	244	
102662	112	
102686	165	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95930	4	
96228	9	

Picklist Print

August-08-13 8:01:12 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

AN3-35A *AN3-35A*
Bolt

Purchased | No | 250 | Each | 195.0000 | **

Location		Loc Qty	Loc Code
FG		10	
	122800	10	
ST352		185	
	125211	160	
	m126400	25	

D3235-1 *D3235-1*
Mounting Lug

Manufactured | No | 250 | Each | 341.0000 | **

Location		Loc Qty	Loc Code
ST466		100	
	102818	100	
ST470		241	
	101559	200	
	90002	2	
	99256	39	

D3278-041 *D3278-041*
Support Assembly

Manufactured | No | 250 | Each | 98.0000 | **

Location		Loc Qty	Loc Code
ST466		40	
	102774	40	
ST470		58	
	102349	40	
	103727	16	
	90706	1	
	99297	1	

Picklist Print

August-08-13 8:01:13 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

AN960JD416	NAS1149D0463J	Purchased	No		250	Each	0.0000	16	160

AN960JD416

Washer

AN960JD516	NAS1149D0563J	Purchased	No		250	Each	2.0000	4	40

AN960JD516

Washer

Location	Loc Qty	Loc Code
ST504	2	
1069059	2	

AN5-36A		Purchased	No		250	Each	311.0000	2	20

AN5-36A

Bolt

Location	Loc Qty	Loc Code
ST338	308	
123525	1	
M126105	307	
ST517	3	
125388	3	

D2618		Manufactured	No		250	Each	444.0000	2	20

D2618

Bushing

Location	Loc Qty	Loc Code
ST013	444	
101708	106	
102964	100	
103863	113	
89275	1	
97780	124	

Picklist Print

August-08-13 8:01:13 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

D2230-3	Manufactured	No		250	Each	652.0000	4	40

D2230-3
MOUNTING LUG

Location	Loc Qty	Loc Code
FG	4	
89045	4	
ST469	648	
101450	69	
101495	108	
101911	292	
102326	100	
102758	44	
89782	19	
90514	1	
94957	4	
96117	7	
97815	2	
97903	2	

101450 80
101495 32

Picklist Print

August-08-13 8:01:13 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

D2856-400	Manufactured	No	250	f	333.9392	12

D2856-400

ABRASION STRIP 4" WIDE (PER FOOT)

Location	Loc Qty	Loc Code
ST408	277.4052632	
101773	212.4	
99378	65.0052632	99378
ST410	15.06	
95159	15.06	
ST415	41.4739	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	

*** cut (2) at 7.20" (D2856-400-720) ***

Picklist Print

August-08-13 8:01:13 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

MS21042L3	Purchased	No		250	Each	7.418.000	20

MS21042L3

Nut

Location		Loc Qty	Loc Code
FP001		3	
	122141	3	
GA		18	
	122452	18	
ST314		891	
	111668	1	
	117885	32	
	119017	55	
	119075	138	
	123265	43	
	M126036	622	126036
ST506		1506	
	123900	912	
	124291	594	
ST510a		5000	
	M126275	1000	
	M126333	4000	

Picklist Print

August-08-13 8:01:13 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

AN4-13A *AN4-13A* Bolt	Purchased	No		250	Each	2.395.000 **	8 (80)

Location	Loc Qty	Loc Code
FG	20	
122808	20	
Return2012	8	
122416	8	
ST511	1000	
m126193	1000	
ST513	11	
111925	2	
121652	4	
125388	5	
ST514	1356	
122993	13	
123900	10	
m125709	1333	125709

MS21042L5 *MS21042L-5* Nut	Purchased	No		250	Each	1,425.000 **	2 (20)

Location	Loc Qty	Loc Code
ST314	444	
125654	444	125664
ST506	1	
123900	1	
st507	980	
125535	980	

Picklist Print

August-08-13 8:01:14 AM

Work Order ID: 105511 *105511*

Parent Item: D350-591-311 *D350-591-311*

Parent Item Name: Heli-Access-Step LH

Start Date: 8/08/13 **Required Date:** 8/15/13

Start Qty: 10.00 **Required Qty:** 10.00

MS21042L4	Purchased	No		250	Each	6.324.000	**

MS21042L4

Locknut

Location		Loc Qty	Loc Code
FP001		50	
	122452	38	
	8182	12	
ST314		10	
	m125708	10	
st507		90	
	116507	10	
	125535	47	
	m126073	33	
ST509		4000	
	m126275	4000	
ST510a		1952	
	m126333	1952	
ST518		222	
	124231	222	

AN960JD10	NAS1149D0363J	Purchased	No	250	Each	0.0000	**

AN960JD10

WASHER

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

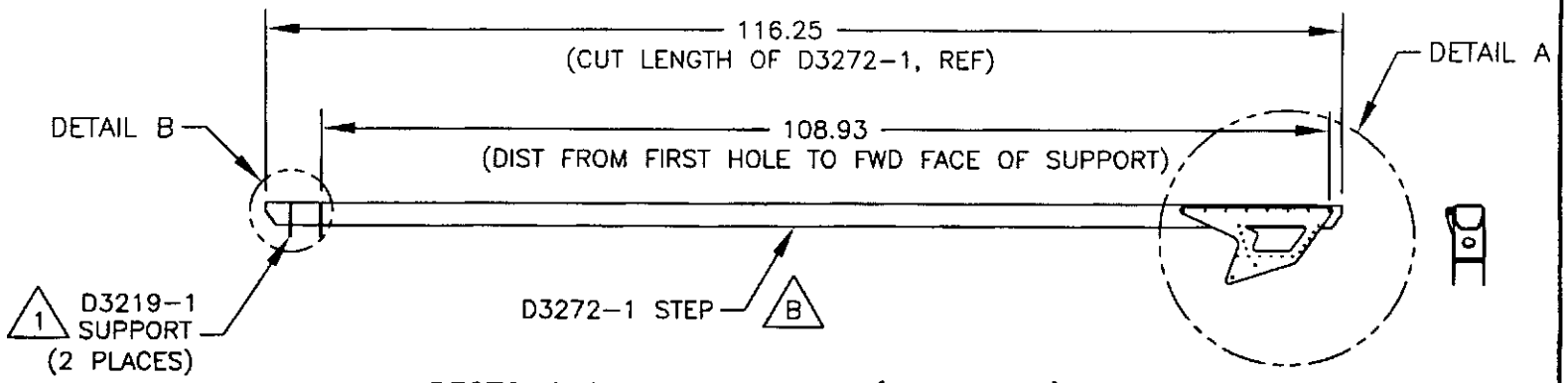
GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

ISSUE MCJ 13-08-08

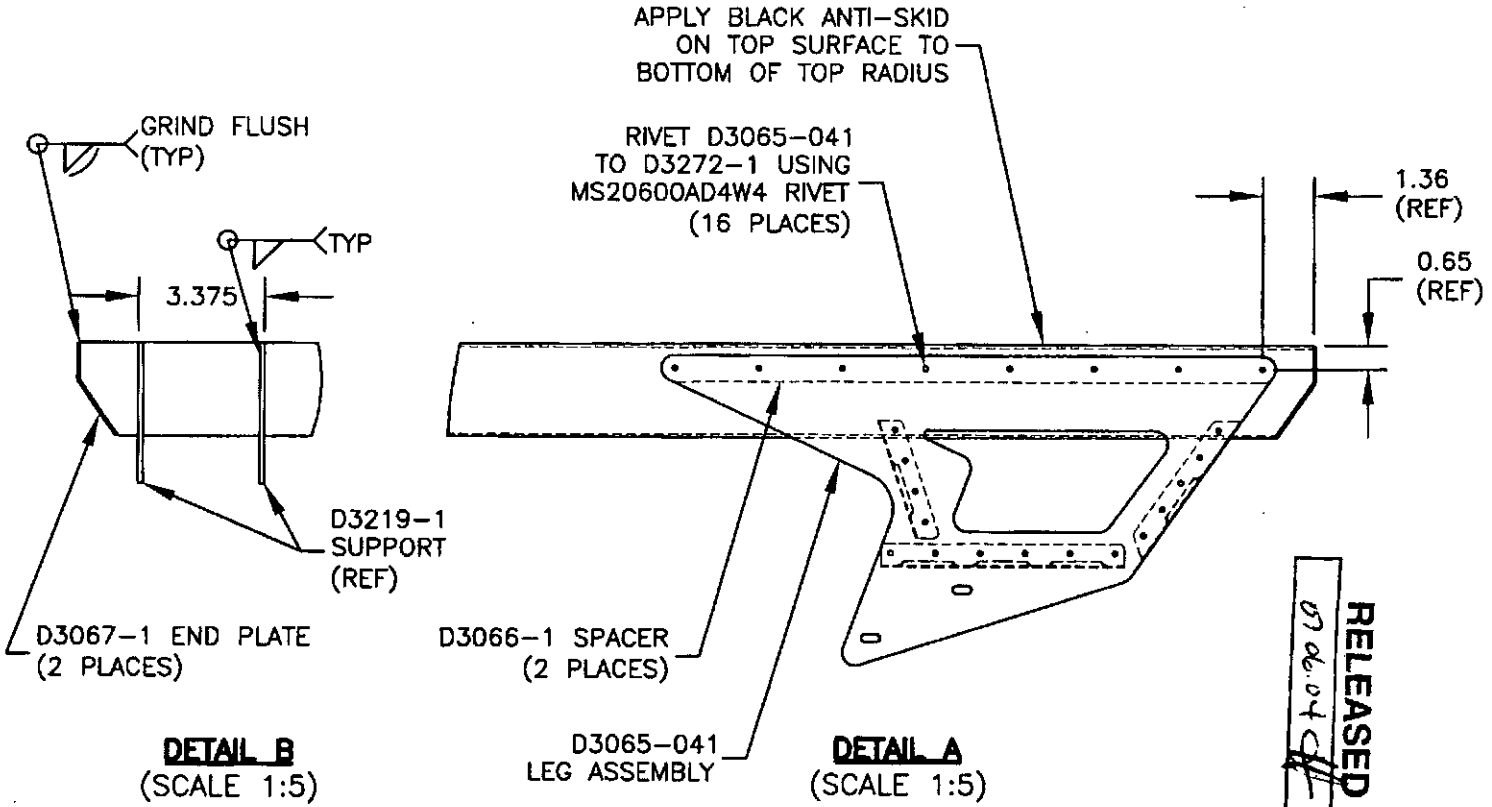
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105511



D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07.06.04

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. B
DATE	DRAWING NO.		SHEET 2 OF 3
07.05.18	D3272		SCALE 1:20
	TITLE	STEP ASSEMBLY, HI LONG	

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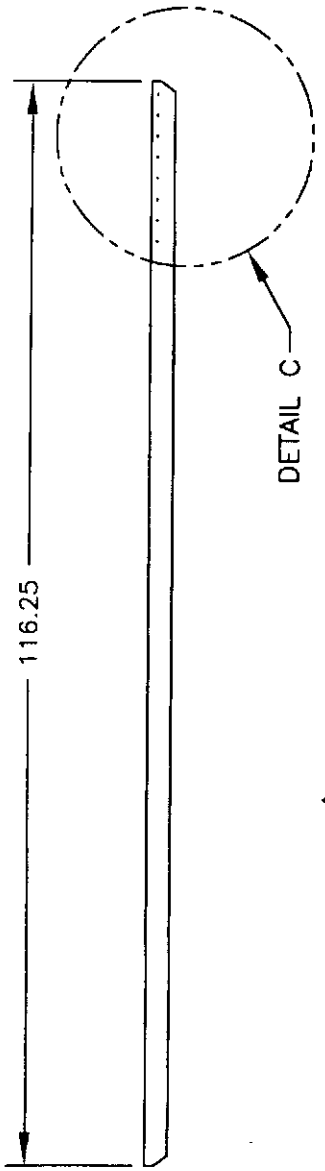
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10551

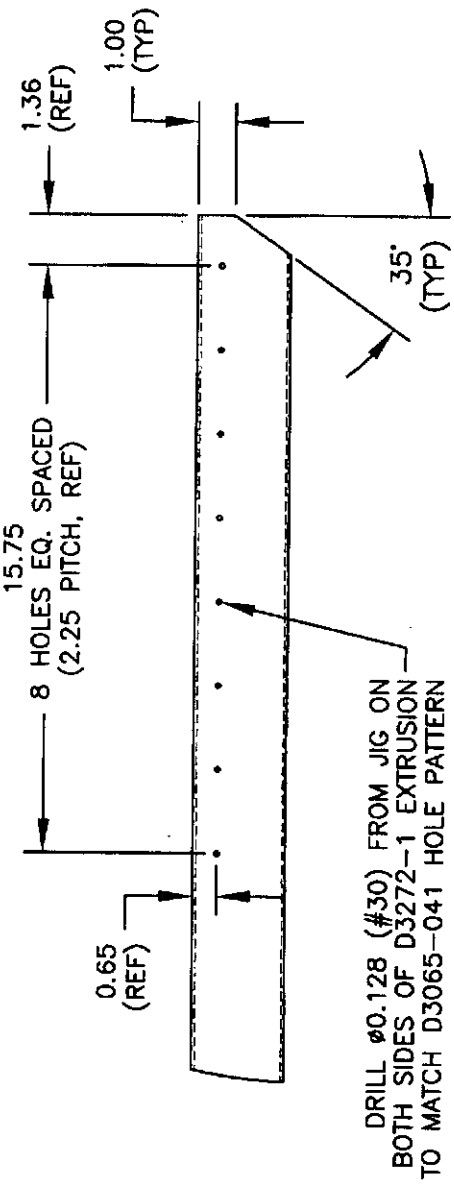
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07 06.04



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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